Work Order ID 95392

95392

January-09-13 12:37:58 PM

Item ID: D3651-5
Accept *N900040100*
Setup Start *NS1*
Stop *NS2*
Revision ID:
Item Name: Top Flange

Start Date: 1/14/13 **Start Qty:** 4.00 *4*
Required Date: 1/25/13 **Req'd Qty:** 4.00 *4*
Cust Item ID:
Customer:
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** MLJ **Date:** 13-01-10 **Tooling:** ______ **Date:** ______
QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D3651	Rev B

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 *100* Waterjet FLOW CNC Waterjet 354.08	FLOW WATER JET **Memo** 1-Cut as per Dwg D3651 Dwg Rev: B Prog Rev: B 2-Deburr if necessary	0.00 0.00				4	0		JM 13-2-13
110 *110* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00				4	0		JM 13-2-13
120 *120* QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00 ShD 13.2.13				4			

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ________	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Part No. ________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Work Order ID 95392
January-09-13 12:37:58 PM

95392

Item ID: D3651-5
Revision ID:
Item Name: Top Flange

Accept *N900040100*

Setup **Start** *NS1*
Stop *NS2*

Start Date: 1/14/13 **Start Qty:** 4.00 *4*
Required Date: 1/25/13 **Req'd Qty:** 4.00 *4*
Reference:

Cust Item ID:
Customer:

Run **Start** *NR1*
Stop *NR2*

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________
QC: ________ ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Brake NC Brake NC	Form as per dwg NC BRAKE **Memo**	0.00 0.00				4			80 13/02/14
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00 SMB 13.2.14				4			
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: W/A 001 **Memo**	0.00 0.00				4	EC	13-2-14	

DQA: ________ Date: ______________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ______________	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Part No. ______________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ______________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	______________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	______________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	______________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Work Order ID 95392

January-09-13 12:37:58 PM

95392

Item ID: D3651-5
Revision ID:
Item Name: Top Flange

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Start Date: 1/14/13 **Start Qty:** 4.00 *4*
Required Date: 1/25/13 **Req'd Qty:** 4.00 *4*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______
QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190*	QC21- Final Inspection - Work Order Release	0.00					13/2/19		
QC Quality Control	Memo	0.00							

MF
13-2-15

DQA: ________ Date: ________________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ______ Part No. ______ NCR No. ______	**DISPOSITION** Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	**AGAINST DEPARTMENT/PROCESS** Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐ Equip/Tooling ☐ Operator ☐ Material ☐ Setup ☐ Other ☐ Process ☐ Supplier ☐ Training ☐ Unapproved ☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other ______

Picklist Print

January-09-13 12:37:57 PM

T

Work Order ID: 95392

Parent Item: D3651-5

Parent Item Name: Top Flange

Start Date: 1/14/13 **Required Date:** 1/25/13

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP RevA 10.11.04 as per revB DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S26GA 304/316 0.018 SHEET		Purchased	No			100	sf	303.3400	**0.3**	~~1.263158~~ 1.3			JM 13-2-13

Location	Loc Qty	Loc Code	
MAT020	303.34		
117798	69.28		
122753	97.06		
123135	137		123135

DQA: ________ Date: ________________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________________

Part No. ____________________

NCR No. ____________________

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ________
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	________________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	________________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	________________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	95392
Description: Top Flange	Part Number:	D3651-5
Inspection Dwg: D3651 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

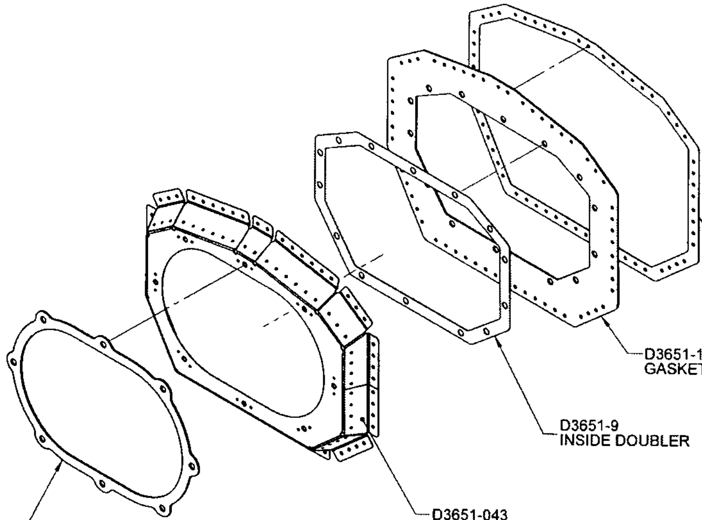
[X] First Article [ ] Prototype

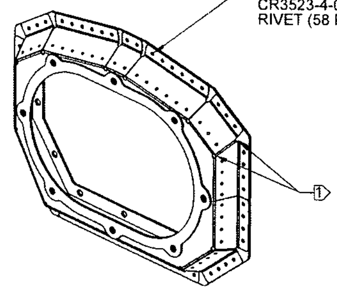
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.098"	–		V	JKM01
Ø0.129	+0.005/-0.001	0.129"	–		V	
0.26	+/-0.030	0.264"	–		V	
0.26	+/-0.030	0.265"	–		V	
2.21	+/-0.030	2.217"	–		V	
1.66	+/-0.030	1.655"	–		V	
3.16	+/-0.030	3.161"	–		V	
0.36	+/-0.030	0.364"	–		V	
0.33	+/-0.030	0.330"	–		V	
0.500	+/-0.010	0.502"	–		V	
0.33	+/-0.030	0.332"	–		V	
0.500	+/-0.010	0.499"	–		V	
0.450	+/-0.010	0.453"	–		V	
0.19	+/-0.030	0.197"	–		V	
0.98	+/-0.030	0.991"	–		V	
0.48	+/-0.030	0.483"	–		V	
0.25	+/-0.030	0.251"	–		V	

Measured by:	Jm	Audited by:	SmB	Prototype Approval:	N/A
Date:	13-2-13	Date:	13.2.13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.10.07	New Issue P/O D3651-043	KJ/DD [signature]	[signature]

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 95392 MO
13-01-10





PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	**D3651-041**	**AFT BASE ASSEMBLY**
1	D3651-043	FLANGE WELDMENT
1	D3651-1	GASKET
1	D3651-9	INSIDE DOUBLER
1	D3651-11	GASKET
1	D3651-13	OUTSIDE DOUBLER
58	CR3523-4-02 or NAS9307M-4-02	RIVET

RELEASED 08-03-27

D3651-041 AFT BASE ASSEMBLY

D3651-041 NOTES:
1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 1.6 lbs

REV.	DESCRIPTION	BY	DATE
B	SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 8.50; 0.88 WAS 0.98; REMOVED ANGLE SHEETS 4, 5, 6, 8 & 9: GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504	RF	08.01.07
A	NEW ISSUE	RF	07.11.07

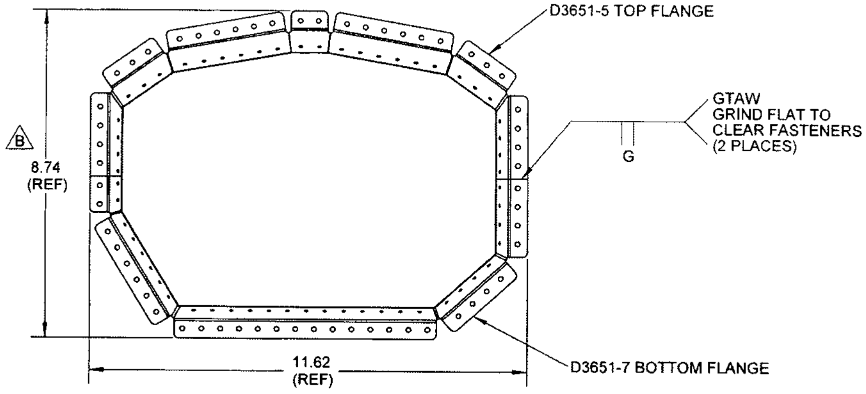
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DRAWN	RF
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	08.01.07

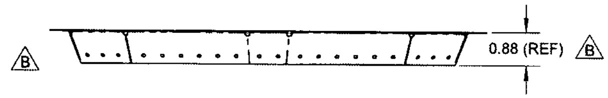
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

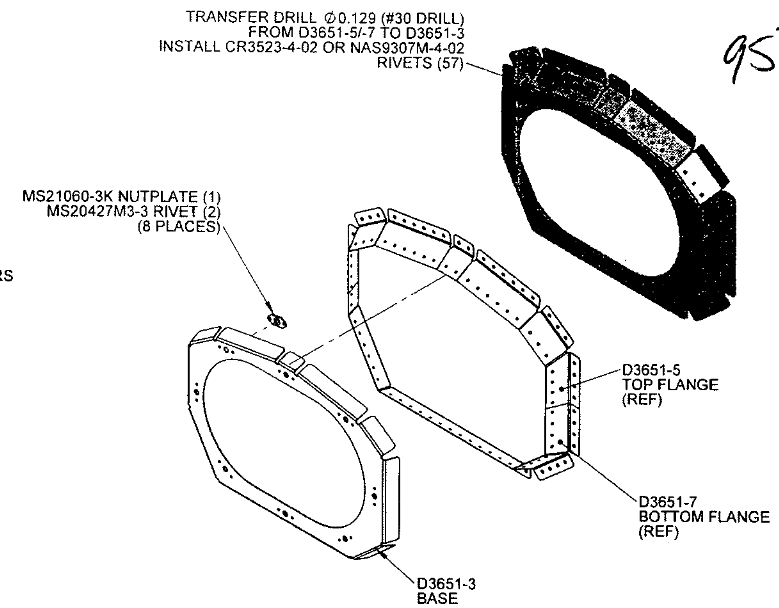
DRAWING NO. D3651 — REV. B — SHEET 1 OF 9

TITLE: AFT BASE ASSEMBLY — SCALE 1:4

95392







D3651-043 FLANGE WELDMENT

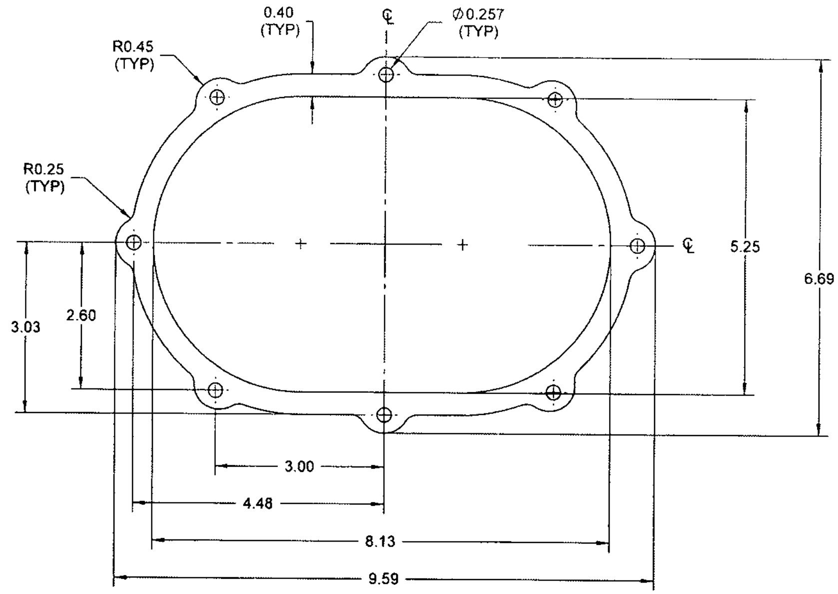
QTY -043	PART NUMBER	DESCRIPTION
X	D3651-043	FLANGE WELDMENT
1	D3651-3	BASE
1	D3651-5	TOP FLANGE
1	D3651-7	BOTTOM FLANGE
16	MS20427M3-3	RIVET
8	MS21060-3K	NUTPLATE
57	CR3523-4-02 or NA9307M-4-02	RIVET

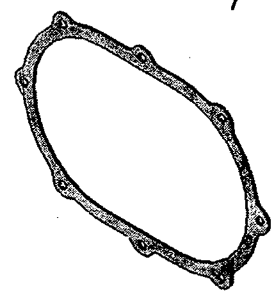
RELEASED 08.03.27

D3651-043 NOTES:
1) WELD PER QSI 004
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.76 lbs

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	[signature]	DRAWING NO. D3651 — REV. B — SHEET 2 OF 9
MFG. APPR.	[signature]	
APPROVED	[signature]	TITLE AFT BASE ASSEMBLY — SCALE 1:3
DE APPR.	[signature]	
DATE	08.01.07	

95392





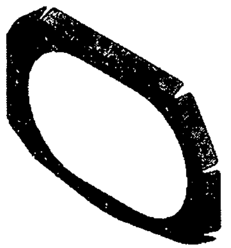
D3651-1 GASKET

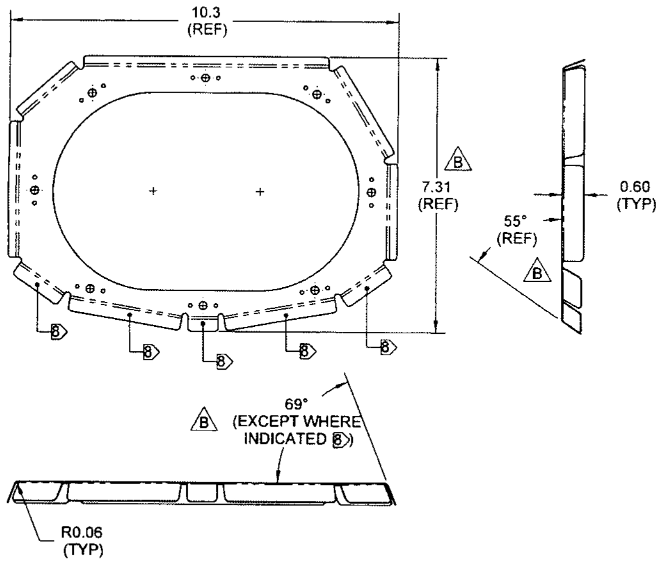
NOTES:
1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) PART IS SYMMETRIC ABOUT ℄
8) WEIGHT: 0.09 lbs

RELEASED 08.03.27

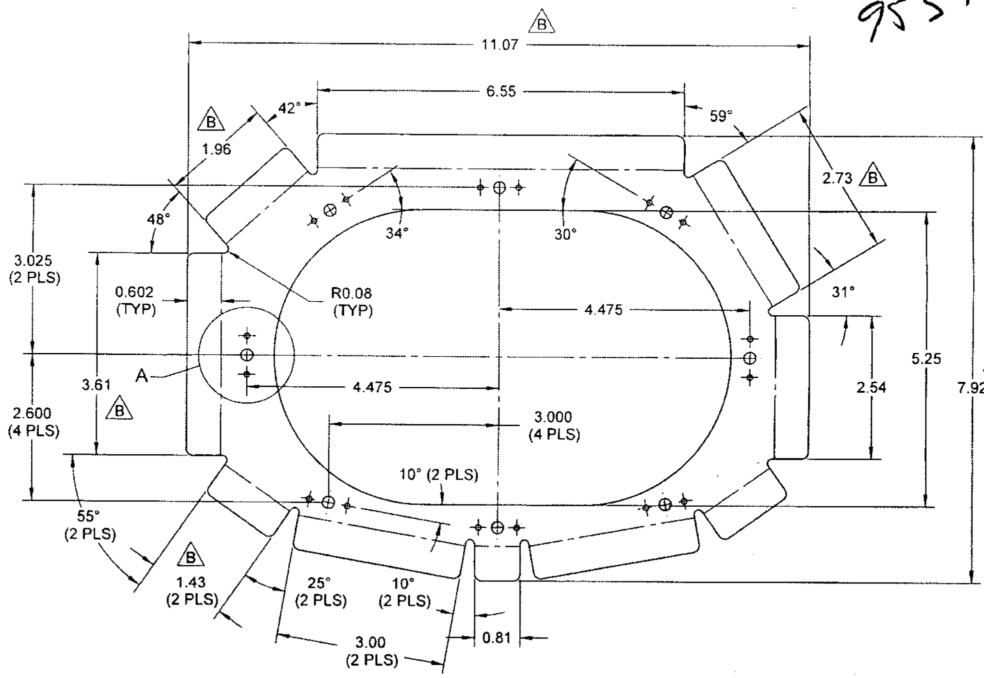
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DRAWN	RF	
CHECKED		DRAWING NO. D3651 — REV. B — SHEET 3 OF 9
MFG. APPR.		
APPROVED		TITLE AFT BASE ASSEMBLY — SCALE 1:2
DE APPR.		
DATE	08.01.07	

95392

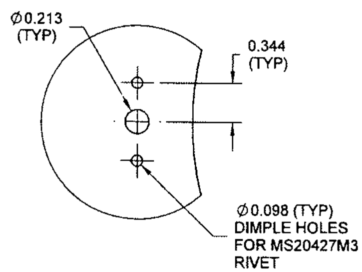




D3651-3 BASE
(MAKE FROM D3651-3F FLAT PATTERN)



D3651-3F FLAT PATTERN



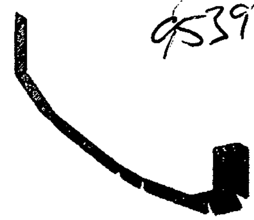
DETAIL A

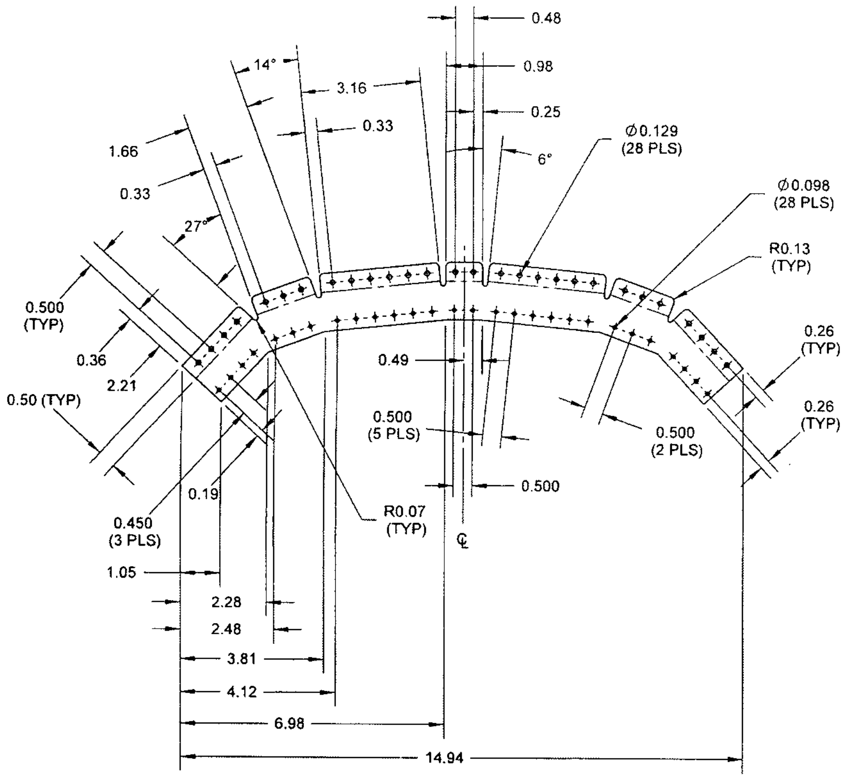
NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.27 lbs
8) BEND TO 55° WHERE INDICATED

08.03.27

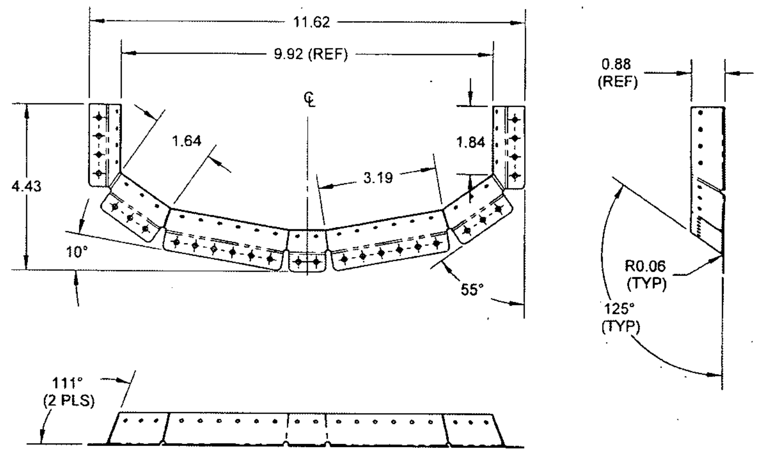
DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. D3651 — REV. B — SHEET 4 OF 9
CHECKED		
MFG. APPR.		
APPROVED		TITLE AFT BASE ASSEMBLY — SCALE 1:2
DE APPR.		
DATE	08.01.07	

95392





D3651-5F FLAT PATTERN (B)



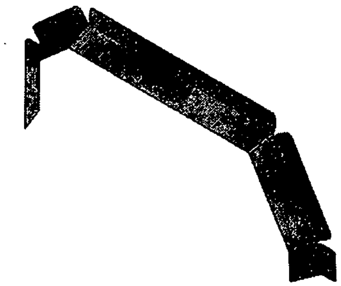
D3651-5 TOP FLANGE BEND DETAIL (B)
(MAKE FROM D3651-5F FLAT PATTERN)

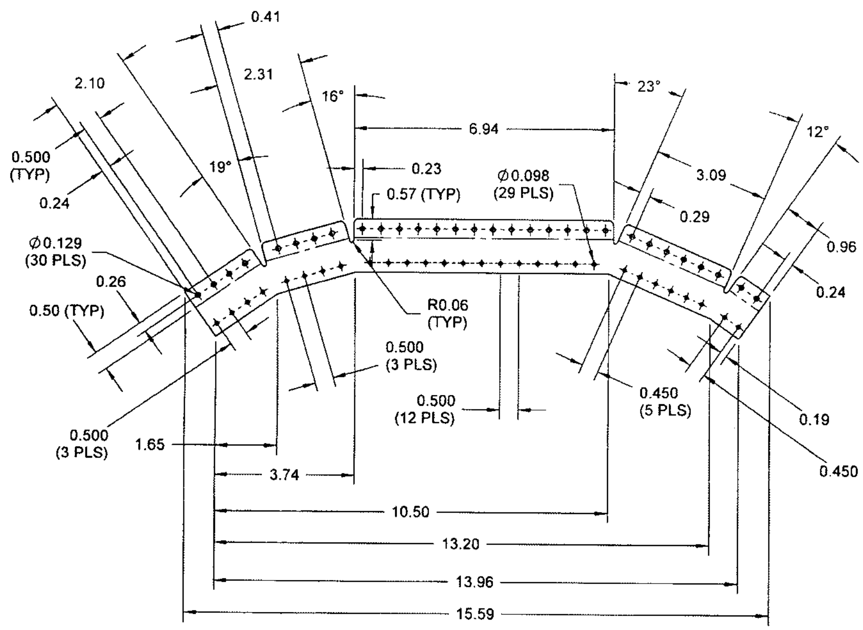
08-03-27 MP

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019
(REF. DART SPEC. M304S26GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.02 lbs

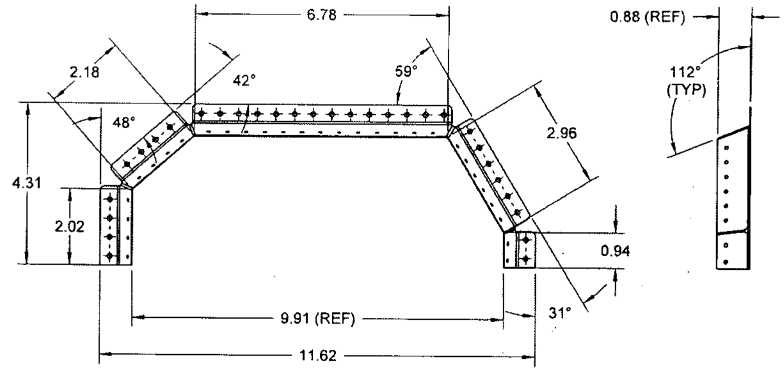
DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	[signature]	DRAWING NO. D3651 — REV. B — SHEET 5 OF 9
MFG. APPR.	[signature]	
APPROVED	[signature]	TITLE: AFT BASE ASSEMBLY — SCALE 1:3
DE APPR.	[signature]	
DATE	08.01.07	

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D3651-7F FLAT PATTERN (B)



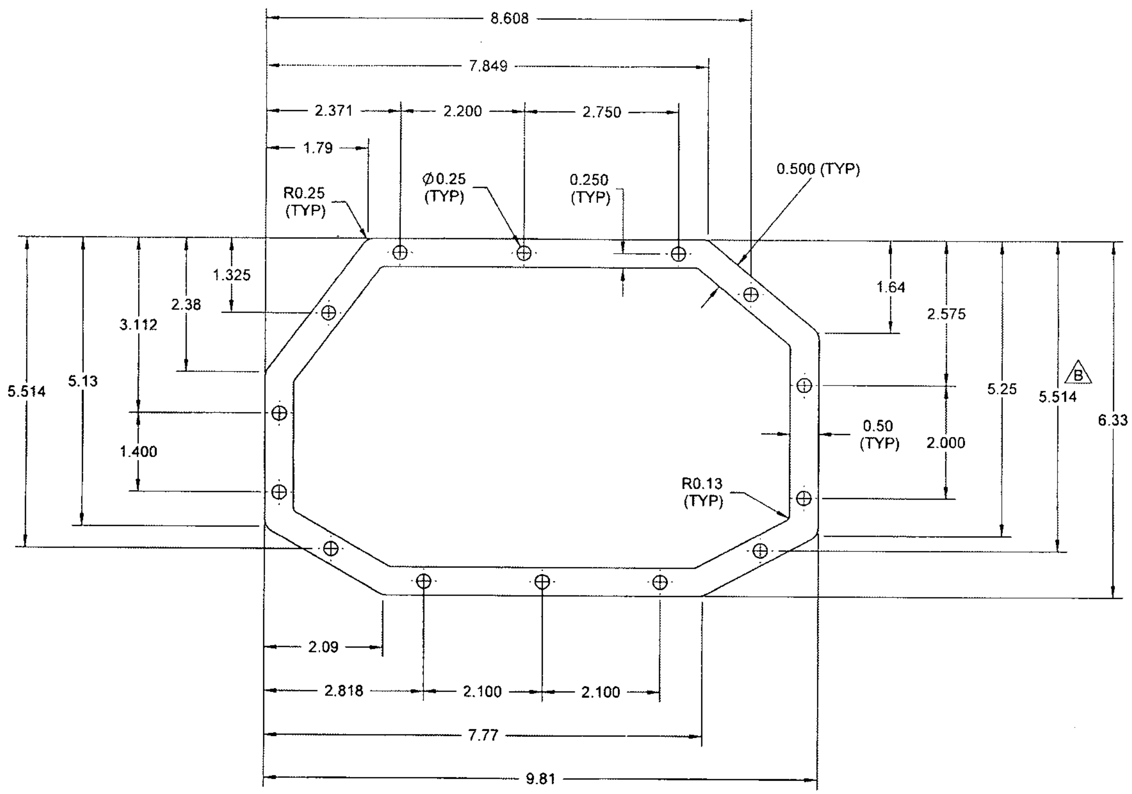
D3651-7 BOTTOM FLANGE BEND DETAIL (B)
(MAKE FROM D3651-7F FLAT PATTERN)

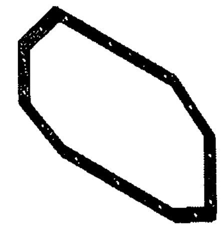
08.03.27

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QS' 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.02 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. D3651 — REV. B — SHEET 6 OF 9
CHECKED		
MFG. APPR.		TITLE: AFT BASE ASSEMBLY — SCALE 1:3
APPROVED		
DE APPR.		
DATE	08.01.07	

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D3651-9 INSIDE DOUBLER

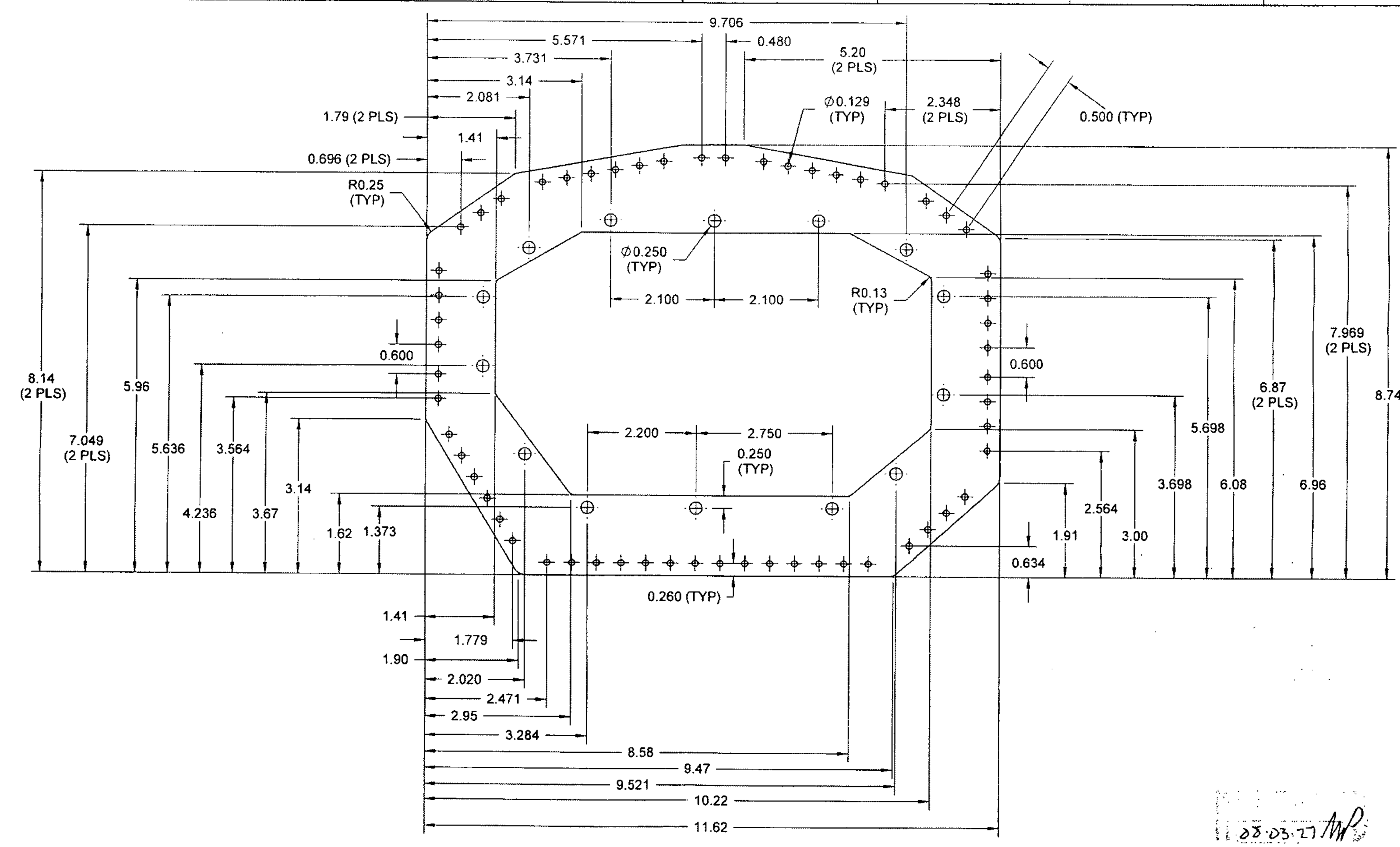
08.03.27

NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.07 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. D3651 REV. B SHEET 7 OF 9
MFG. APPR.		
APPROVED		TITLE AFT BASE ASSEMBLY SCALE 1:2
DE APPR.		
DATE	08.01.07	

95392



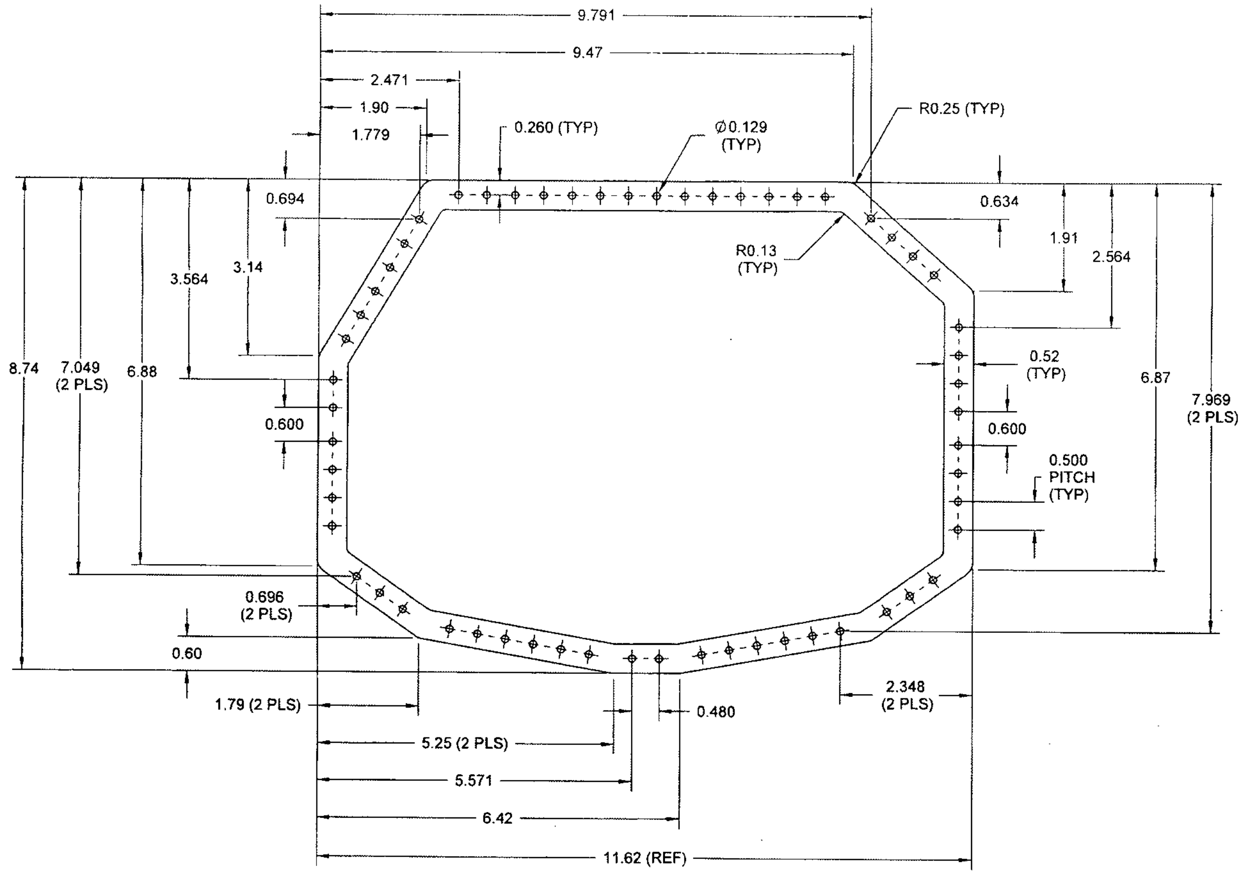
08.03.27

D3651-11 GASKET B

NOTES:
1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.2 lb

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. D3651 — REV. B — SHEET 8 OF 9
CHECKED		TITLE: AFT BASE ASSEMBLY — SCALE 1:2
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	08.01.07	

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08.03.27

D3651-13 OUTSIDE DOUBLER B

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.10 lbs

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. D3651 — REV. B — SHEET 9 OF 9
CHECKED		
MFG. APPR.		TITLE: AFT BASE ASSEMBLY — SCALE 1:2
APPROVED		
DE APPR.		
DATE	08.01.07	